



# CEWELD AlMg 4.5MnZr Tig

|                                                |                                                                                                                                                                                                                                                                                                                                    |                                   |      |                         |      |                      |      |        |          |     |      |
|------------------------------------------------|------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|-----------------------------------|------|-------------------------|------|----------------------|------|--------|----------|-----|------|
| TYPE                                           | Tig filler rods for welding Aluminium Magnesium alloys                                                                                                                                                                                                                                                                             |                                   |      |                         |      |                      |      |        |          |     |      |
| ANWENDUNGEN                                    | Construction of ships, piping, off-shore, storage tanks, railways and automotive industry.                                                                                                                                                                                                                                         |                                   |      |                         |      |                      |      |        |          |     |      |
| EIGENSCHAFTEN                                  | Special alloy for welding aluminium-magnesium based alloys with maximum 5% Mg. Zirconium added as grain refiner to improve both the bending and corrosion resistance.                                                                                                                                                              |                                   |      |                         |      |                      |      |        |          |     |      |
| KLASSIFIKATION                                 | AWS                                                                                                                                                                                                                                                                                                                                | A 5.10: ER5087                    |      |                         |      |                      |      |        |          |     |      |
|                                                | EN ISO                                                                                                                                                                                                                                                                                                                             | 18273: S Al 5087 (AlMg4,5MnZr(A)) |      |                         |      |                      |      |        |          |     |      |
|                                                | F-nr                                                                                                                                                                                                                                                                                                                               | 22                                |      |                         |      |                      |      |        |          |     |      |
| GEEIGNET FÜR                                   | Aluminium alloys: AlMg4,5Mn, AlZnMgCu1,5, AlMg5, AlMg3, AlMg5, AlMg2Mn0.8, AlMg2,7Mn, AlZn4,5Mg1, AlZnMg4,5Mn ,AlZn5,5Mg1, AlZn5,5Mg1,5, G-AlMg3Si, G-AlMg5Si, G-AlMg10, G-AlMgSi1, AlMgSiCu<br>EN AW 5086, EN AW 6060, EN AW 6005A, EN AW , EN AW 6061, EN AW 7020, EN AW 7021, EN AC 51400, EN AC 51300, EN AC 51100, EN AW 5454 |                                   |      |                         |      |                      |      |        |          |     |      |
| ZULASSUNGEN                                    | CE                                                                                                                                                                                                                                                                                                                                 |                                   |      |                         |      |                      |      |        |          |     |      |
| SCHWEISSPOSITIONEN                             |                                                                                                                                                                                                                                                   |                                   |      |                         |      |                      |      |        |          |     |      |
| TYPISCHE CHEMISCHE ANALYSE DES FÜLLMETALLS (%) | Si                                                                                                                                                                                                                                                                                                                                 | Mn                                | Cr   | Ti                      | Fe   | Cu                   | Zn   | Al     | Mg       | Zr  | Be   |
|                                                | 0.05                                                                                                                                                                                                                                                                                                                               | 0.7                               | 0.09 | 0.07                    | 0.13 | 0.03                 | 0.01 | Rem.   | 4.8      | 0.1 | 0.00 |
| MECHANISCHE GÜTEWERTE                          | Heat Treatment                                                                                                                                                                                                                                                                                                                     |                                   |      | R <sub>P0,2</sub> (MPa) |      | R <sub>m</sub> (MPa) |      | A5 (%) | Hardness |     |      |
|                                                | As Welded                                                                                                                                                                                                                                                                                                                          |                                   |      | 125                     |      | 275                  |      | 17     | HRc      |     |      |
| RÜCKTROCKNUNG                                  | Not required                                                                                                                                                                                                                                                                                                                       |                                   |      |                         |      |                      |      |        |          |     |      |
| GAS ACC. EN ISO 14175                          | I1                                                                                                                                                                                                                                                                                                                                 |                                   |      |                         |      |                      |      |        |          |     |      |